

Split
-2

ASAP

Work Order ID 146146

146146

Page 1

Friday, May 06, 2016 11:32:51 AM

Item ID: D3256-1

Accept

N900040100

Setup Start *NS1*

Revision ID:



Item Name: Panel

Stop *NS2*

Start Date: 5/6/2016

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/10/2016

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: mkf

Date: 16-5-5

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3256	E Custom								
100	FLOW WATER JET	0.00							
100									
Waterjet									
FLOW CNC Waterjet									
	Memo								
	1-Cut as per Dwg D3256								
	Dwg Rev: _____								
	Prog Rev: _____								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC									
Quality Control									
	Memo								
120	QC8- Inspect parts - second check	0.00							
120									
QC									
Quality Control									
	Memo								

DAS
22
9-89

1605.00

custom, see attached email
mkf
16-5-5

(6)

16/05/09

(6)

16/05/09

(6)

DAS
38
9-89

MAY 10 2016

Friday, May 06, 2016 11:32:51 AM

146146

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

* 1 *

Cust Item ID:

Start Date: 5/6/2016 **Start Qty:** 1.00

* 1 *

Customer:

Required Date: 5/10/2016 **Req'd Qty:** 1.00

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

0.00

DAS
30
9-89

JUN 08 2016

130

NC BRAKE

0.34

Brake NC

Memo

Form using D3256-1T2

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.34

Quality Control

150

Identify as per dwg & Stock Location: QC office 0.00

0.00

150

Packaging .

Memo

0.01

Packaging

Work Order ID 146146

Friday, May 06, 2016 11:32:51 AM

146146

Page 3

Item ID: D3256-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Panel

Start Date: 5/6/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/10/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

DAS
21
9-89

JUL 05 2016

160

QC

Memo

0.10

Quality Control

MW JUN 13 2016

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED 6 DATE 16.06.14

DAS
22
9-89

Picklist Print

Page 1

Friday, May 06, 2016 11:32:51 AM

Work Order ID: 146146

146146

Parent Item: D3256-1

D3256-1

Parent Item Name: Panel

Start Date: 5/6/2016

Required Date: 5/10/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased		No		100	sf	143.8750	0.987	1.038947			

M304S22GA

304/316 .032 Sheet

**

26/16/05/09

Location

Loc Qty

Loc Code

MAT020

143.875

m126593

28.475

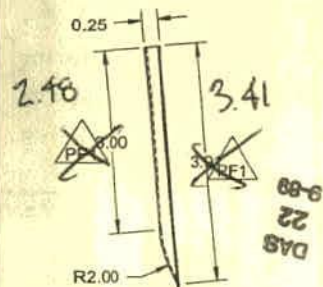
m131999

51.4

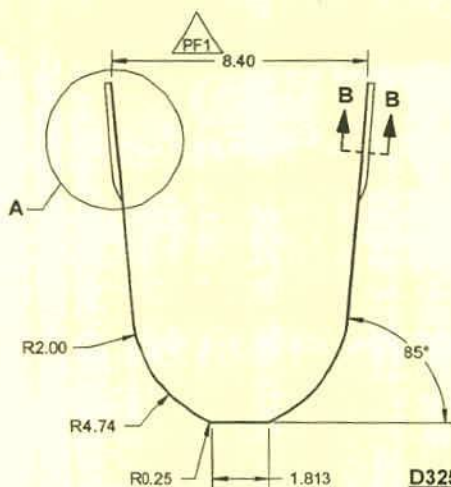
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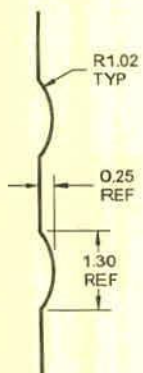
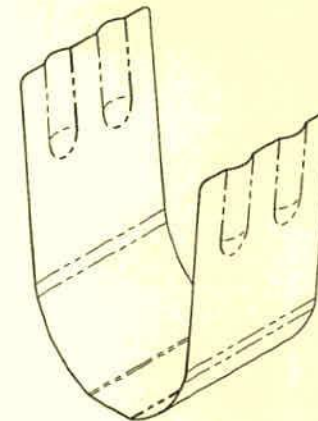
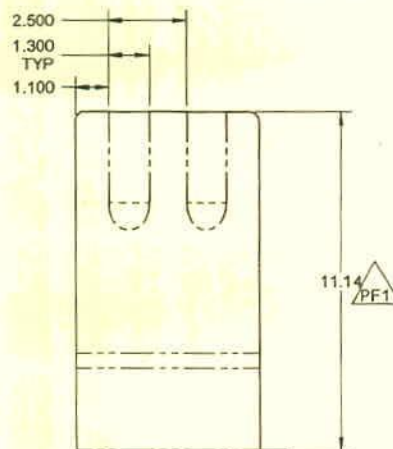
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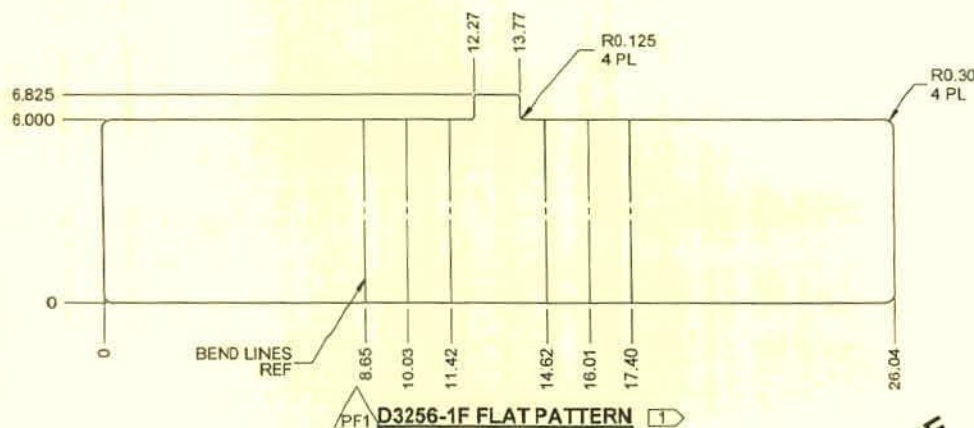
DETAIL A
SCALE 2X



D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)



SECTION B-B
SCALE 2X
(VIEW ROTATED)



PRELIMINARY ISSUE
12.10.16

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.032 THICK PER MIL-S-5019 OR AMS 5513/AMS 5524 OR ASTM A240 OR ASME SA240 REF. DART SPEC. M304S22GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 1.49 lbs

REV.	DESCRIPTION	BY	DATE
PF1	REVISED D3256-1F/A-3 TO PROVIDE MORE EDGE DISTANCE AT INSTALL. REF. PAR16-516.	MB	16.04.16
E	CHANGED MATERIAL FOR D3256-3. REASON: PROCUREMENT, REF CAR12-09.	MB	12.10.16
D	UPDATED TO COMPLY WITH QSI 043; REMOVED "FORM JOGGLE PER D3256-1T1" AND "FORM PER D3256-1T2" (SEE PREVIOUS REV FOR REFERENCE); 6.825 WAS 6.450 (ZN B7-1); 0.63 WAS 0.45 (ZN C8-2). REASON: PAR11-124.	MB	11.10.25
C	D3256-041 ELIMINATED; REMOVED (QTY.22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3256 ACCESS PANEL COPYRIGHT © 2004 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	DATE 12.10.16		
DATE	REV. PF1 SHEET 1 OF 2 SCALE NTS		

Melanie Fauteux

From: Marc Bellavance
Sent: Friday, May 06, 2016 11:22 AM
To: Melanie Fauteux
Cc: Shirley Hay; Denis Maranda; Sian Willems
Subject: FW: Supporting Bell Helicopter
Attachments: D3256-1_RevPF1.pdf; D3256-1F_RevPF1.dxf; D3256-3 RevE_CUSTOM.pdf; D3256-3 RevE_CUSTOM.dxf; D3206_RevPB1.pdf; D3206-3F_RevPB1.dxf

Importance: High

Hi Mel,

As discussed, please see below.

Also:

1. Just got off the phone with Bell and D412-705-015 should be put under review and any WIP on hold if not done already. This kit is not working on Bell 412 EPI and tweaks are required. As a result, Bell would now need:
 - Qty(1) D3256-1 per attached drawing and DXF.
 - Qty(2) D3256-3 per attached drawing and DXF.
 - This would ensure they can complete ships 1 and 2. Based on this, other 5 kits would need to be amended accordingly but this is still TBD.
2. D412-704-015 Kit: some tweaks required for fit on Bell 412 EPI. Next revision of this kit will add D3206-3. We have already provided them with qty(1) on prelim and they confirm resolution of the issue (SO125967). They have 7 ships so we would need to make qty(6). If possible, qty(1) required for next week. Drawing and DXF attached.

Same as recently, I would be delivering the parts. Next visit is scheduled for May 10 but I don't mind pushing it back to May 13.

Please let me know what is possible to do here. If a meeting is required then please let's have one. ☺

Thanks,
Marc

From: Marc Bellavance
Sent: May-06-16 8:44 AM
To: Denis Maranda <dmaranda@dartaero.com>
Cc: Sian Willems <swillems@dartaero.com>; Patrick Smith <psmith@dartaero.com>
Subject: FW: Supporting Bell Helicopter
Importance: High

Hi Denis,

I will have to put a no charge in our system for this; please advise.

Thanks,
Marc

From: Marc Bellavance
Sent: May-05-16 2:40 PM
To: Denis Maranda <dmaranda@dartaero.com>
Cc: Sian Willems <swillems@dartaero.com>; Patrick Smith <psmith@dartaero.com>
Subject: Supporting Bell Helicopter
Importance: High

Hi Denis,

Following my visit to Bell last week, work continued on the D3256-1/-3 we provided them with. However, it was brought to my attention that they have scrapped D3256-3 Gasket while trying to install it on the aircraft. Bell was asking for a "blank" version which they could trim as required. See attached what the custom part would look like.

Sian agreed to the replacement at no charge. We would also require a second blank part for our own reverse engineering purposes. My next visit to Bell is scheduled for the morning of Tuesday, May 10.

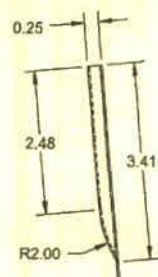
Does this give you enough time to have the part manufactured?

Marc Bellavance
Mechanical Designer / Technical Support

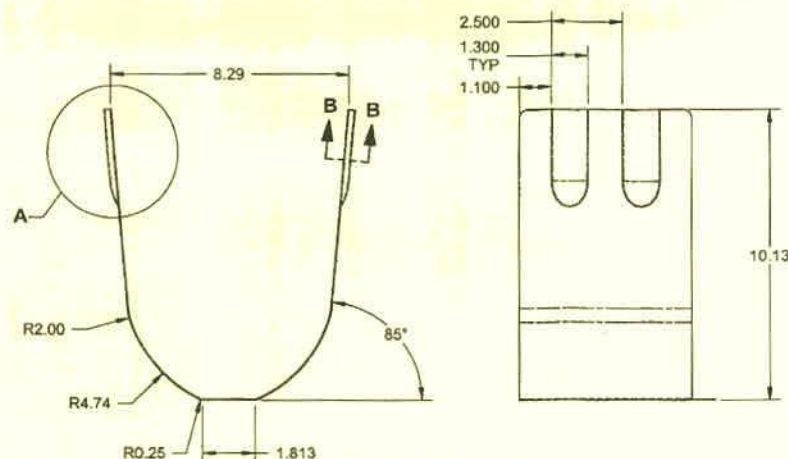
DART AEROSPACE
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M 1 613 676 0992
F 1 613 632 9311
S marcbellavance
www.dartaerospace.com



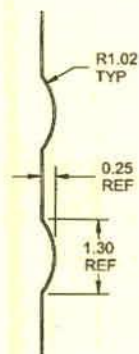
Technical Publications: Verify Revision Status/Download [HERE!](#)



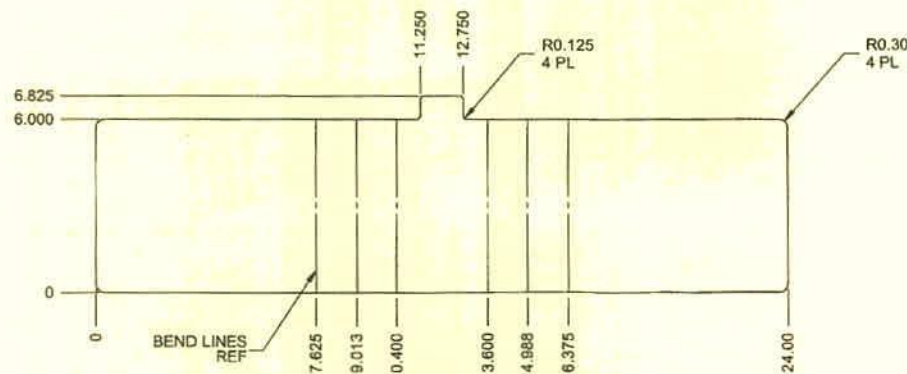
DETAIL A
SCALE 2X



D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)



SECTION B-B
SCALE 2X
(VIEW ROTATED)



D3256-1F FLAT PATTERN [1]

RELEASED
2012-11-08

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.032 THICK
PER MIL-S-5019 OR AMS 5513/AMS 5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N "BXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.37 lbs

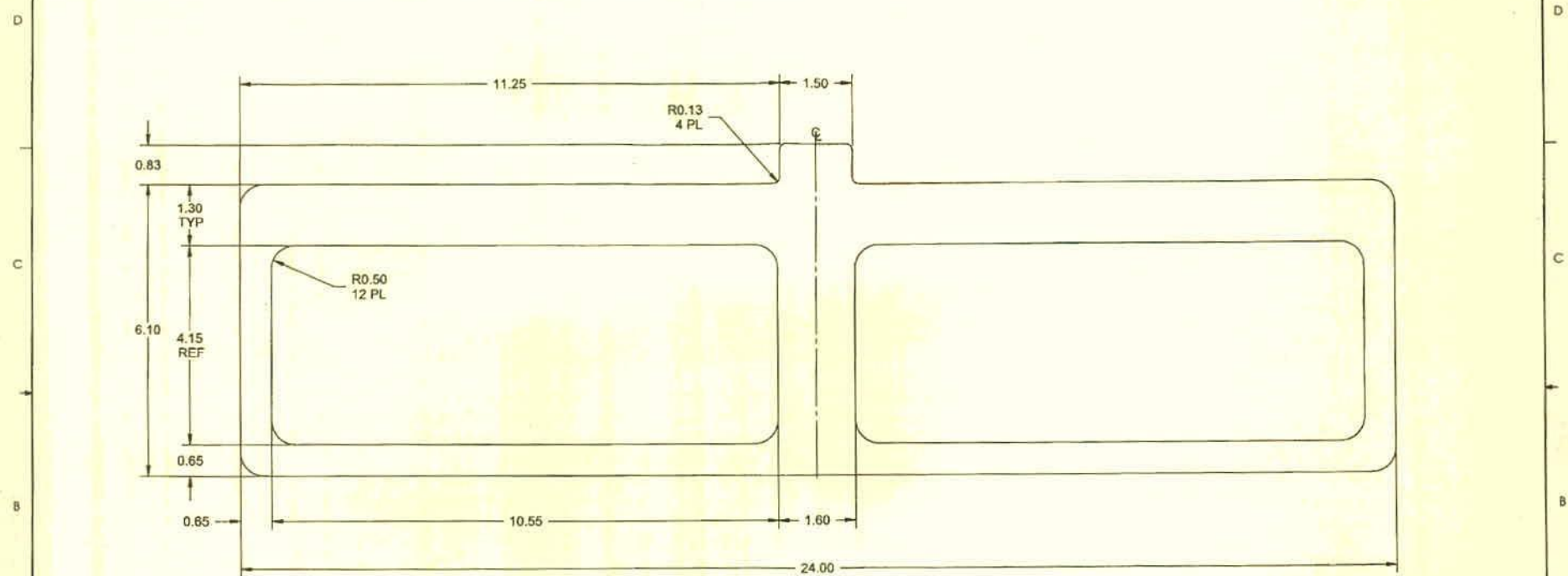
E	CHANGED MATERIAL FOR D3256-3. REASON: PROCUREMENT, REF CAR12-69.	MB	12.10.16
D	UPDATED TO COMPLY WITH QSI 043; REMOVED "FORM JOGGLE PER D3256-1T1" AND "FORM PER D3256-1T2" (SEE PREVIOUS REV FOR REFERENCE); 6.825 WAS 6.450 (ZN B7-1); 0.83 WAS 0.45 (ZN C8-2). REASON: PART11-124.	MB	11.10.25
C	D3256-041 ELIMINATED; REMOVED (QTY 22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.10.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3256** REV. E
SHEET 1 OF 2
TITLE **ACCESS PANEL** SCALE NTS

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8 7 6 5 4 3 2 1



D3256-3 GASKET

RELEASED
2012-11-06

- NOTES:**
- 1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: N/A
 - 5) IDENTIFICATION: N/A
 - 6) WEIGHT: 0.12 lbs

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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3256	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL	NTS
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8 7 6 5 4 3 2 1